

Work Order ID 85812-1 *split*

\*85812\*

Page 1

Item ID: D4154-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly

Start Date: 15/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/15*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4154

D

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154  
\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH#: *m122279 -> 20596*

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: *m120013*

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

*(x6) me 12-07-30*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

*6x 12.7.31*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 85812

June-15-12 1:26:49 PM

\*85812\*

Page 2

Item ID: D4154-041  
Revision ID:  
Item Name: Wearplate Assembly  
Start Date: 15/06/2012 Start Qty: 10.00  
Required Date: 29/06/2012 Req'd Qty: 10.00  
Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Cust Item ID:  
Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*  
Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00



12/04/31



Quality Control

150

0.00

\*150\*

Small Fab

Memo

0.00

I- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3  
dwg D4154.

122237

AS

12 - 8 - 2 (6)

Small Fab

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00



Quality Control

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



Work Order ID 85812

June-15-12 1:26:49 PM

\*85812\*

Page 3

Item ID: D4154-041  
 Revision ID:  
 Item Name: Wearplate Assembly  
 Start Date: 15/06/2012 Start Qty: 10.00  
 Required Date: 29/06/2012 Req'd Qty: 10.00  
 Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*  
 Stop \*NS2\*

Cust Item ID:  
 Customer:

Approvals: Process Plan: Date: Tooling: Date:  
 QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
*170*									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

x6 f M n/a 8/02

12/8/13

11/2-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:26:53 PM

Page 1

Work Order ID: 85812

\*85812\*

Parent Item: D4154-041

\*D4154-041\*

Parent Item Name: Wearplate Assembly

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A 10.09.21 new issue DD ver:EC  
10.11.04 added DT9684 DD ver:EC  
per dwg revB DD ver:EC

IPP Rev:B  
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 *D4154-1* Plate		Manufactured	No			100	Each	19.0000	1	10	**	(A6) ml 12-07-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
84746 x 6				WA		19							
				66312		1							
				83217		12							
				84746		6							
D4155-1 *D4155-1* Bar		Manufactured	No			100	Each	16.0000	1	10	**	(A6) ml 12-07-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
85842 x 6				WA030		16							
				83218		10							
				83846		6							



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 85812 M2J  
12/06/15

RELEASED  
2012-05-09  
MD

# D4154-041 WEARPLATE ASSEMBLY

D	70 45 WAS 74.45 & 100.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2). ADD HARDCOAT (ZN B7-2). ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1). REMOVED FINISH TO NOTE 2 (A8-2). REMOVED SECTION A-A (NO LONGER REQUIRED). REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	12.05.03	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS NEED TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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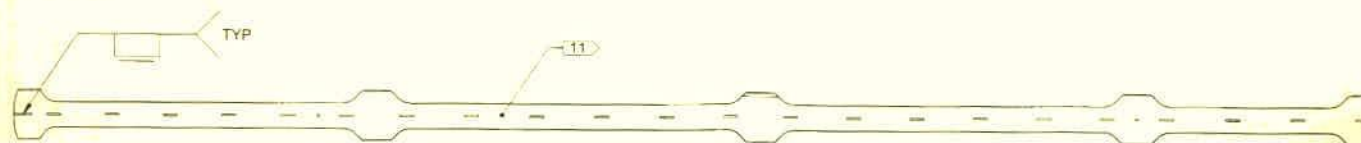
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

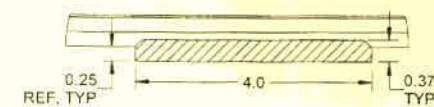
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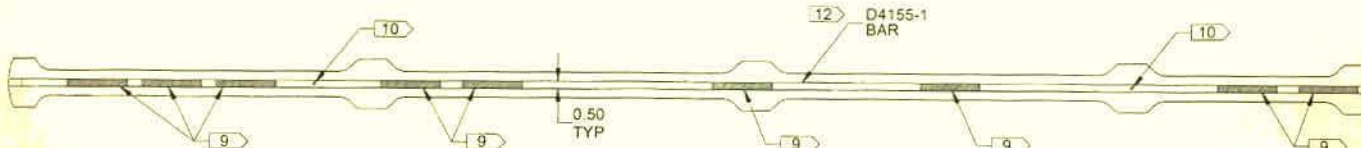
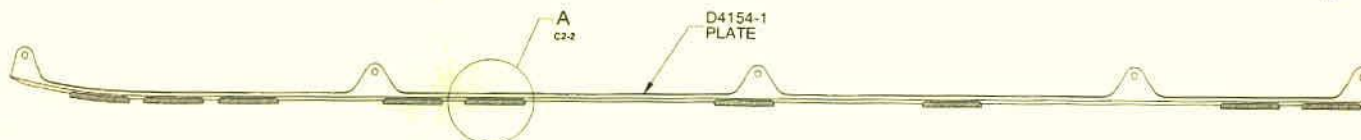




85812



DETAIL A  
TYP C5-2



**D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2012-05-09  
MP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL  $\varnothing$  0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

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MFG. APPR.	RF	D4154	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSEMBLY	NTS
DATE	12.05.03	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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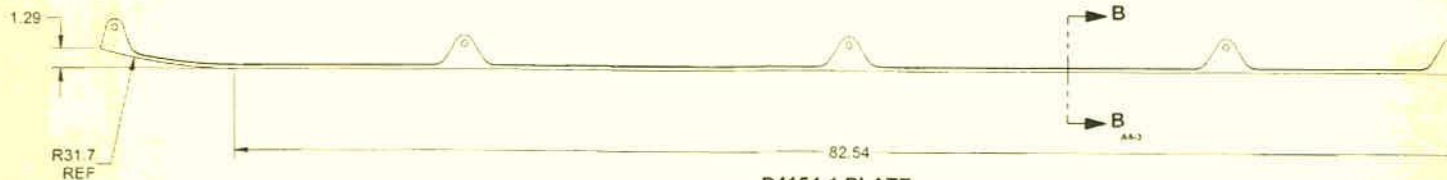
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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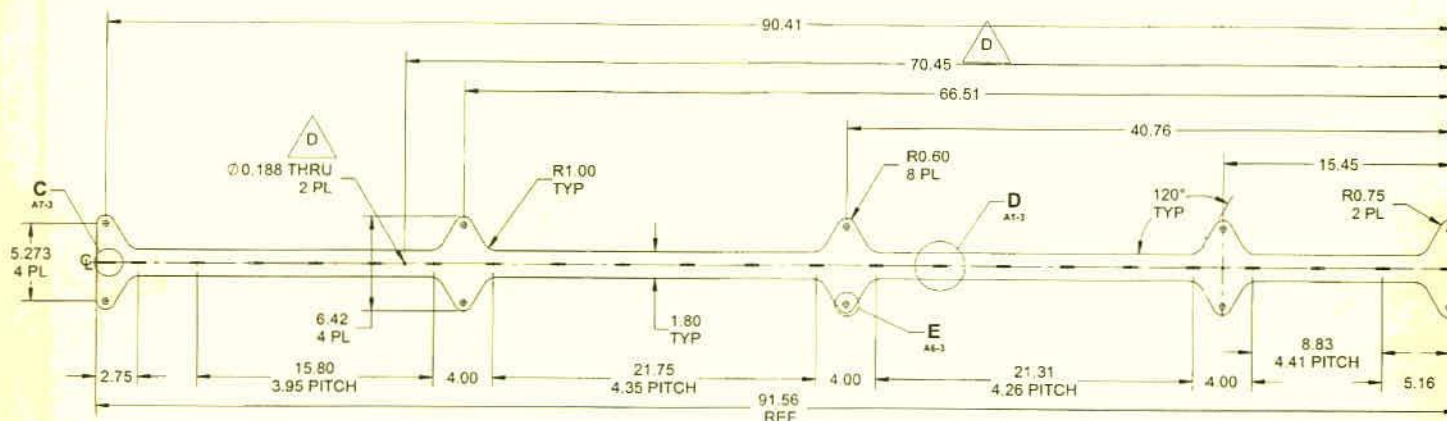
**NOTE:** Date & initial all entries



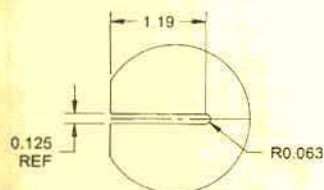


**D4154-1 PLATE**  
(MAKE FROM D4154-1F)

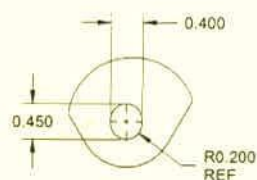
**RELEASED**  
2012-05-09



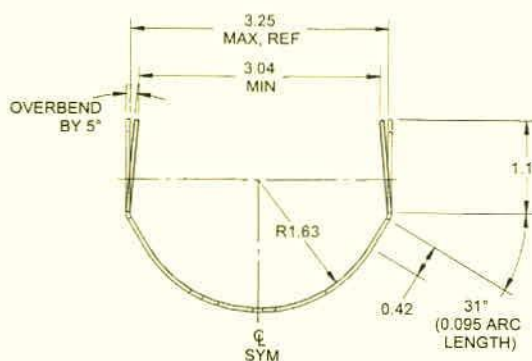
**D4154-1F FLAT PATTERN**



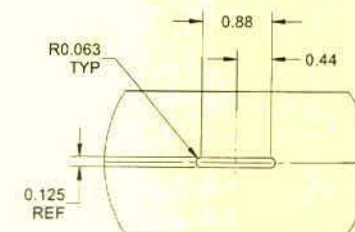
**DETAIL C**  
END SLOT DETAIL, 2 PL



**DETAIL E**  
SLOT DETAIL TYP



**SECTION B-B**



**DETAIL D**  
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4154</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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